

Date: Friday, 29/08/2008 11:39:13 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG ASSEMBLY
Job Number	: 41678		
Estimate Number	: 10816		
P.O. Number	:	Part Number	: D3175041
This Issue	: 29/08/2008 S.O. No. :	Drawing Number	: D3175 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 25025	Material	:
Written By	:	Due Date	: 10/09/2008
Checked & Approved By	: <u>JLD 08-8-29</u>	Qty:	5
Comment	: Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.50 x 2.50
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Comment: Qty.: 0.2012 f(s)/Unit Total : 0.8047 f(s)
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11)
 (M6061T6B1.500x02.500) Batch: M16716

mm 08/09/09

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 (2) blanks required per (1) D3175-041 assembly
 Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2")

mm 08/09/09

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA293 and Dwg D3175
 Deburr and Tumble
 Identify as D3175-1

J.L 08/09/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/09/11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S.F 08/09/11 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/08/2008 11:39:14 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG ASSEMBLY

Job Number: 41678

Part Number: D3175041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h 08/09/12 **(10X)**

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

08-09-12 **(X10)**

8.0

D31753

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description
1	D3175-3	Spacer

Batch
25027

CU

9.0

AN37A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN3-7A	Bolt

Batch
2152 M5288

CU

10.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	AN960JD10L	Washer

Batch
1105793

CU

11.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	MS21042L3	Nut

Batch
1108201

CU 8/9/12 **(E)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/08/2008 11:39:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG ASSEMBLY

Job Number: 41678

Part Number: D3175041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3175

CP 08/09/23 (5)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/09/23 (X5)

14.0

POWDER COATING

POWDER COATING



M 108523



(5X)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*8-30
320 °C
9-00*

M-L 08/09/24

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



41



Comment: INSPECT POWDER COAT

08-09-24 (X5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *473*

8/9/24

(5X)

SP

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26 (X)

Job Completion



u 08/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

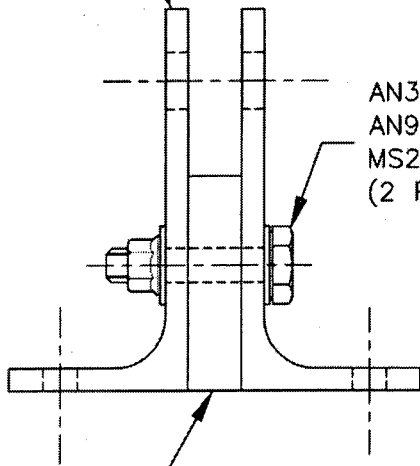
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

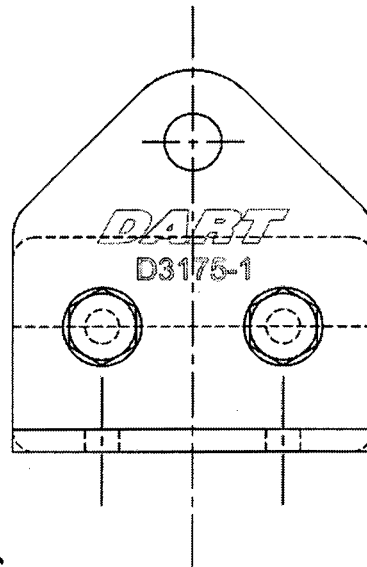


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03	TITLE MOUNTING LUG		SCALE 1:1
A	02.12.03	NEW ISSUE	

D3175-1
(2 PLACES)



AN3-7A BOLT (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)

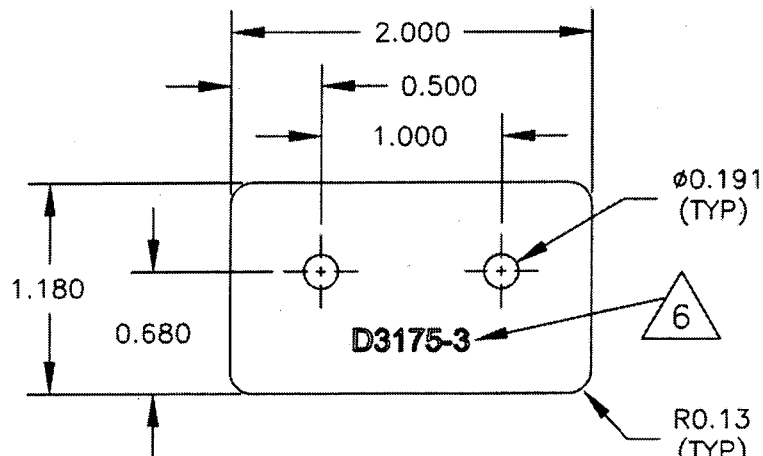


D3175-3

D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3

RELEASED
02.12.03 #



D3175-3 SPACER

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

R0.13 (TYP)
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41628

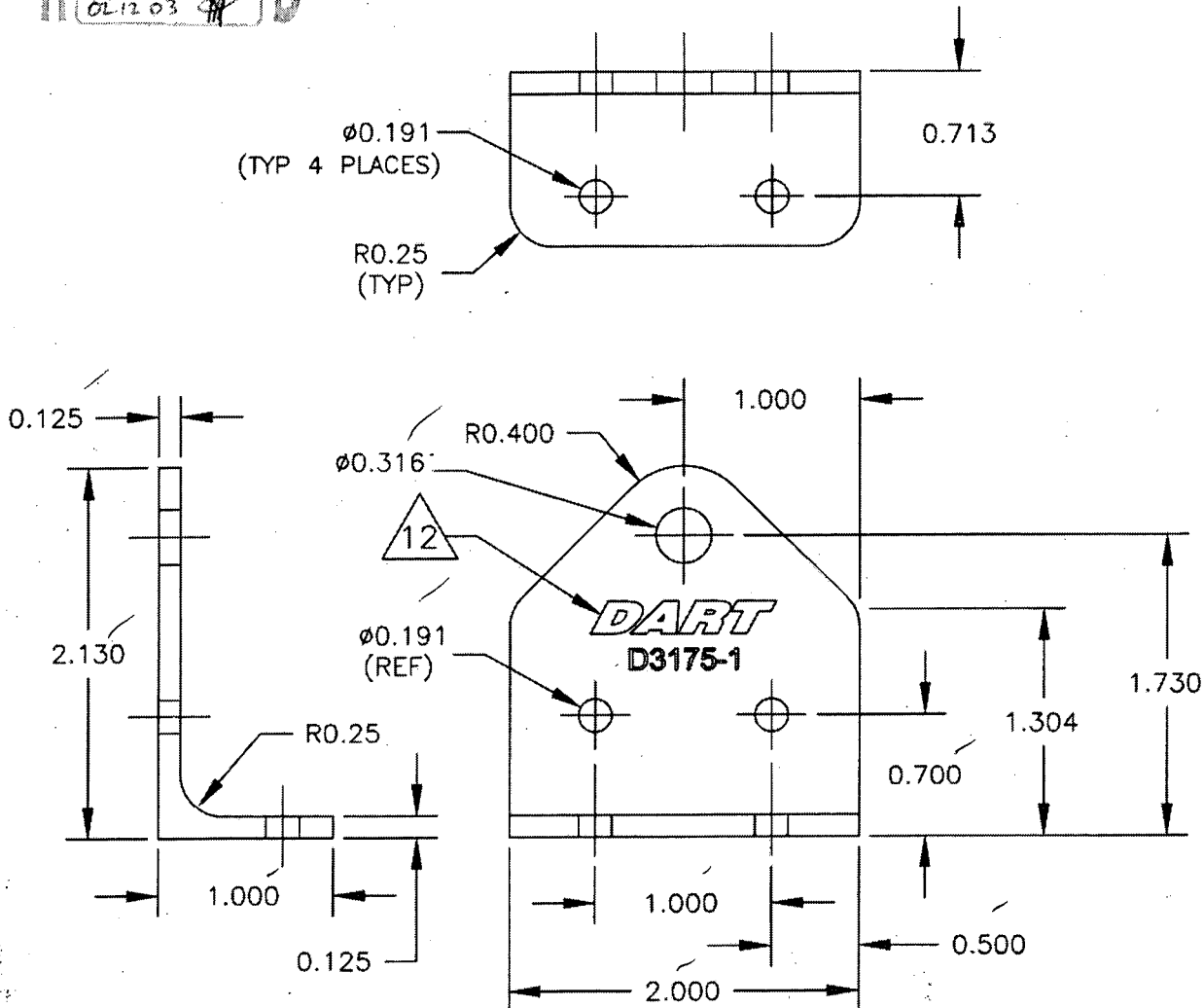
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
02.12.03



D3175-1 BRACKET

7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)

8) BREAK ALL SHARP EDGES 0.005 TO 0.015

9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

11) ALL DIMENSIONS ARE IN INCHES

12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX WITHOUT NOTICE

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